

Date: Tuesday, 4/17/2007 3:55:02 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WEARPAD
Job Number	31911		
Estimate Number	12801		
P.O. Number	N/A	Part Number	D35377
This Issue	4/17/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Number	D3537 UNDER REVIEW
First Issue	N/A	Project Number	N/A
Previous Run	31401	Drawing Revision	A/B/C PH 07.04.27
Written By		Material	N/A
Checked & Approved By		Due Date	5/10/2007
Comment	Est Rev:A New Issue 07-03-12 ec	Qty:	16
Um:	Each		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet Comment: Qty.: 0.1512 sf(s)/Unit Total : 2.4192 sf(s) M304S16GA Stainless steel sheet 0.063" thick Batch: M119052 ML 07 05 07 16
2.0	WATER JET	FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3537 Dwg Rev: C Prog Rev: C ML 07 05 07 16
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE 16
4.0	QC8	SECOND CHECK Comment: SECOND CHECK 16
5.0	BRAKE NC	NO BRAKE Comment: NC BRAKE Deburr if necessary Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. SB 07/05/08 16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/05/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/17/2007 3:55:02 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 31911

Part Number: D35377

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

107/05/09 16

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty	Description	Batch
A/R	2059B Hardcoat	M102956
Weld hardcoat as per Dwg D3437		

FC 07/05/10 16

8.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

107/05/10 16

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

107/05/10 16

10.0 POWDER COATING

POWDER COATING



M1101 601

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

21

04-03-10 16

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M.R

07/05/10

12.0 PACKAGING 1

PACKAGING RESOURCE #1



16X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

EP 16

M.R 07/05/10

13.0 QC21

FINAL INSPECTION/W/O RELEASE



16

Comment: FINAL INSPECTION/W/O RELEASE

ND 07/05/11

Job Completion



W.D. 07/05/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A'	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31911
Description: Wearpad	Part Number:	D3537-7
Inspection Dwg: D3537	Rev: A/B/C C 07-05-03	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

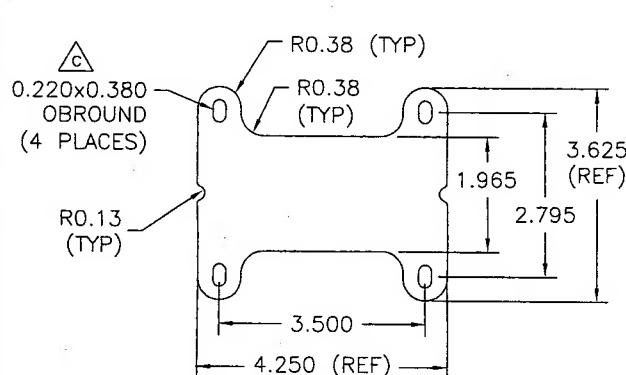
PH
07.04.27

27

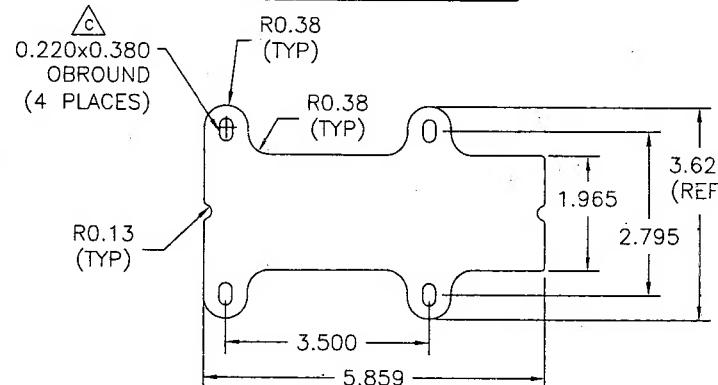
Measured by:	<i>M M</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	07/05/07	Date:	07/05/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM 	

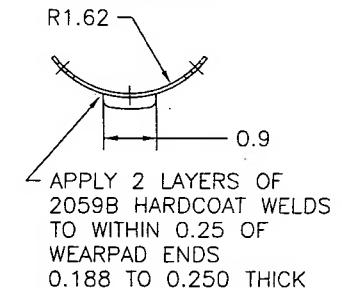
D3537-1F FLAT PATTERN



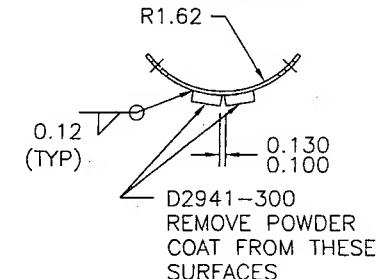
D3537-3F FLAT PATTERN



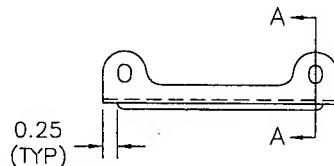
SECTION A-A



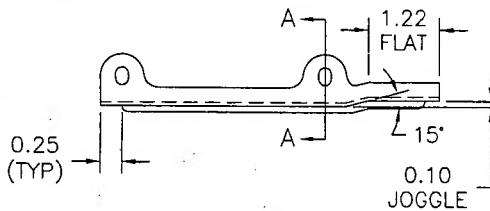
SECTION B-B



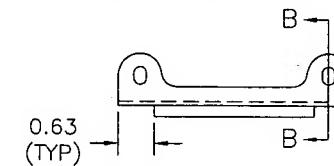
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



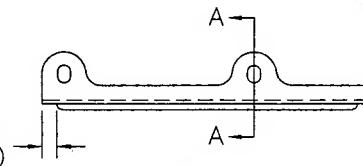
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DESIGN	CB	DRAWN BY	PH	DART AEROSPACE USA, INC. PORT HUENEMER, WA
CHECKED	#	APPROVED	#	DRAWING NO. D3537
DATE	07.04.13	TITLE	WEARPAD	REV. C SHEET 1 OF 1 SCALE 1:2